Work Orde				*957	752	*						Page 1
Item ID: Revision ID: Item Name:	D3204-5 Arm		A	Accept	*/	1900	040	100)* s	Setup Sta	I A	S1* S2*
Start Date: Required Date: Reference:	1/16/13 1/31/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*			Cust Item I Customer:	D:					
Approvals:		an: MUS	Date:/ <u>3-0/-2/</u>	Tooling: SPC (Y/N):			ate:		I	Run Sta Sto		R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr				· · · · · -						
D3204	Rev	/ A1										
*100 *100* Bandsaw Jeaspa Bandsaw		BAND SAW Memo Cut blank: 1.	25" x 0.375" x 3.370" long	0.00 0.00 Bar (+0.030/-0.000)	70	13/0	2/05		0	Ø		
*110		HAAS CNC VERTICAL	MACHINING #1	0.00					10	o		/ S Ays 33
HAAS 1 HAAS CNC vertica	ıl machine #1	Memo 1- Machine a 5	as per Folio FA344 and Dwg	0.00 g D32042- Deburriden	tify as D3:	204-			. <i></i>			13.02.05
120 * 12 0*		QC2- Inspect parts off m	achine FAI/FAIB	0.00					10	d		۲۸. 33.

0.00

13.62-05

Memo

Quality Control

NCR: Yes	/ No				WORK ORDER NON-O	COI	VFOR	MANCE / UF	PDATE	QA Closed	i: Date:	:
Work Order:					DISPOSITION				AGAINST DE	PARTMEN	T/PROCESS	
1 1 1					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet od. Eng. Coor. ore/Packaging Supplier	Engineering Quality Other
Root					ption of work order update	1	Initial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
						AUL	T CATE	GORY				
Landing (Gear Bending Centre N	ot Concer	ntric to (o/s	General Bend BOM/Route		Grain Hardwa	ıre		Ovalized Over/Und	er tolerance	Pressure/Forced Temperature/Cure

DOA.

Part Incorrect

Date:

Weld

Wrong Stock Pulled Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Maintenance Part Moved Contamination Countersink Mislabeled Positioned Wrong Heat Treat Other Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube Outside Dimensions H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Inspection Incomplete

Broken/Damaged

Cracks

Work	Order	· ID	95752
7 7 1 1 I N	.,,,,,	11/	7.11.14

Page 2

Ianuary-18-13 10:24:45 AM

======================================	10.24.43 Al	<i>VI</i>											
Item ID: Revision ID:	D3204-5		·····	Accept	*N	1900	040	100)* s	etup Star	1.71	S1*	
Item Name:	Arm									Stop	*N	S2*	
Start Date:	1/16/13	Start Qty: 10.00	*10*	ŧ		Cust Item I	D:						
Required Date	: 1/31/13	Req'd Qty: 10.00	*10*			Customer:							
Reference:													
Approvals:	Process P	lan:	Date:	Tooling:		Da	ate:		R	un Star	1/7	R1*	
	QC:		Date:	SPC (Y/N):		Da	ate:			Stop	' *N	R2*	
Sequence ID/ Work Center I	ID	Operation Description		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
130		QC8- Inspect parts - seco	nd check	0.00	L	1210	21.			,		08 08 08	
130 QC Quality Control		Memo		0.00	De	12/0	2/06		10			, 08 08	
140		Identify as per dwg & Sto	ck Location:	0.00							11		`
140 Packaging Packaging		Memo	100000 CO 1000	0.00						143/	12/ 7)
150 *150*		QC21- Final Inspection -	Work Order Release	0.00							12-0	1-03	ł
QC Quality Control		Memo		0.00					M	<u>LS</u>	Λ <u>γ</u>	2-07	•

									. •			DQA:	Da	te:	
NCR:	Yes	/ No	,			WORK ORDER NON-O	CON	NFORM	MANCE / UP	DATE		·		-	
												QA Closed:	Da	te:	
Work Ord	or.					DISPOSITION				AGAINST (DE	PARTMENT	PROCESS		
WOIR OIG	L1.					Rework]		Skid-tube	Crosstube]	Water Jet		Engineering
Part I	No.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
		,				Use-as-is]	Therm	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR I	Vo.			,		Work Order Update			Large Fab	Composite]	Supplier		
Root					Descri	ption of work order update		nitial	Act	ion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	iption		Date	Verificatio	n_	QC Inspector
Doc/Data															
Equip/Tooling															
Operator			:												
Material															
Setup															
Other									·			· ·			
Process															
Supplier															
Training							1								
Unapproved							<u> </u>								
						<u> </u>	AUL	T CATE	GORY						
Landi	ng (Gear			_	General		,		-		-			•
		Bending				Bend		Grain		. [Ovalized		L	Pressure/Forced
		Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa	re	<u> </u>		Over/Under	tolerance	<u></u>	Temperature/Cure
,	L	Cracks				Broken/Damaged		Inspecti	on Incomplete	[Part Incorre	ct		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/L	Jnclear [Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	[Part Moved			
		Heat Trea	it			Countersink		Mislabe	led	ſ		Positioned V	Vrong		_
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	l			Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1

January-18-13 10:24:45 AM

Work Order ID:

95752

Parent Item:

D3204-5

Parent Item Name:

Arm

Start Date: 1/16/13

Required Date: 1/31/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.250		Purchased	No			100	f	12.0000	0.2913	3.066316			
6061-T6 Bar .375 x 1.25				Location		Loc Qty	Lo	c Code			20	13102/1	05

120243

12

2.9

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date:	
Work Ordei	r.			÷	DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No	o				Rework Scrap Use-as-is Work Order Update	-	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
		Y									
Root					ption of work order update	Initial		ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling	_										
Operator	_									•	·
Material	4										
Setup	4										
Other	4			·							
Process	4										
Supplier	-										
Training	_										
Jnapproved		l	<u> </u>	<u> </u>		AULT CATE	CORV		<u> </u>		ļ
Landin	- C				General	AULI CAT	GURT			····	
Landin	Bending				Bend	Grain			Ovalized		Pressure/Forced
-	Centre No	ot Conco	ntric to	0/5	BOM/Route	Hardw	aro	-	Over/Under	tolerance	Temperature/Cure
-	Cracks	ot conce	itiit to	^{0/3} -	Broken/Damaged		tion Incomplete	-	Part Incorre	 	Weld
}	Crushed/	Crimped		-	Burrs	_	tions incomplete	/Unclear	Part Lost/Mi	<u> </u>	Wrong Stock Pulled
<u> </u>	Cuffs	cinipeu.	-		Contamination	\vdash	enance	, oncical	Part Moved	1331116	
-	Heat Trea	at		-	Countersink	Mislab		-	Positioned V	Mrong	
-	Inspectio		Tube	-	Cut Too Short	Misrea			Power Loss/		Other
<u> </u>	Ripples in	•	Tube		Drill Holes	Offset		<u> </u>]. 0		10000
<u> </u>	Torque W		Extrusio	_n ⊢	Drawing		Calibration				
F	Turning S			··	Finish		Sequence				
T T	Wave/Tw				Folio	\vdash	e Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	95752
Description: Arm	Part Number:	D3204-5
Inspection Dwg: D3204 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype	Х	First Article		Prototype
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					· - J [
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.375	+/-0.010	375	1		Vem 0-6"	B605
0.750	+/-0.010	1749	_		1	l
R0.50	+/-0.030	·50 y	~			
R0.500	+/-0.010	. - । ७ ५	/			
Ø0.760	+0.005/-0.000	.760	~			
0.080	+/-0.010	. 080	~			
2.373	+/-0.005	7-373	V			
Ø0.375	+0.005/-0.000	.376	/			
0.250	+/-0.010	7.247	/			
R0.06	+/-0.030	-06	/			
0.200	+/-0.010	. 701	/		4	•
			11.00.40			
						YA
					-	

					-	
				i		

Measured by: 3C	Audited by:	D.A	DAS	Prototype Approval:	N/A
Date: 13.02.05	Date:	13/02/06	9-89 08	Date:	N/A

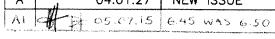
Rev	Date	Change	Revised by	Approved
_ A	05.02.17	New Issue	KJ/JLM	1
В	06.03.21	Dwg Rev update	KJ/JLM 🔏	

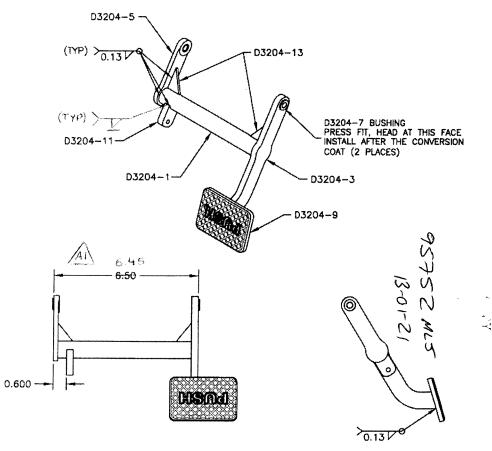




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	CHECKED	M	APPROVED	DRAWING NO.		REV		
	*6	1			SHEET	1 0	F	3
	DATE	V		TITLE		SC	AL.	E
	04.01.27			RELEASE PEDAL ASSEMBLY		1	NT	s
	Α		04.01.27	NEW ISSUE				







D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125) 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
 ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
 7) WELD ASSEMBLY PER QSI 004

- 9) POWDER CONVERSION COAT PER DART QSI 005 4.1
 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 11) ALL DIMENSIONS ARE INCHES

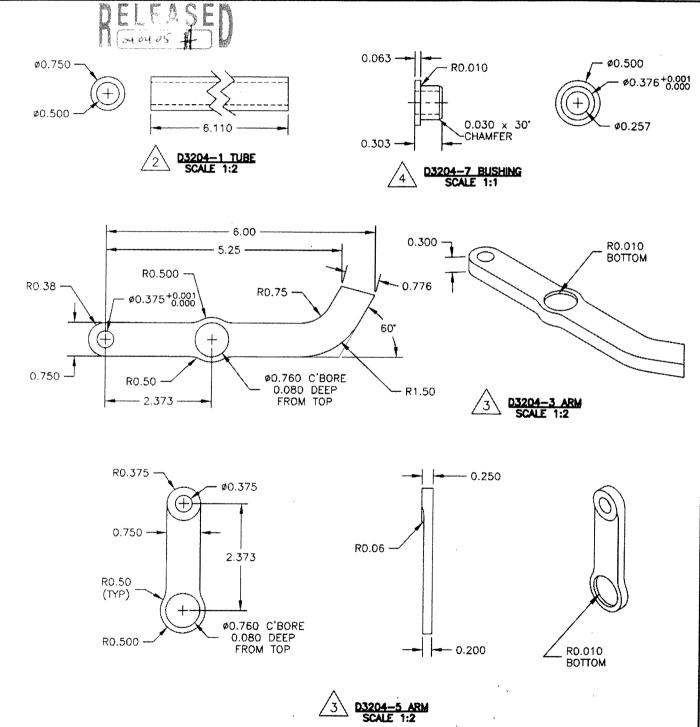
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一	1 4	D3204	SHEET 2 OF 3		
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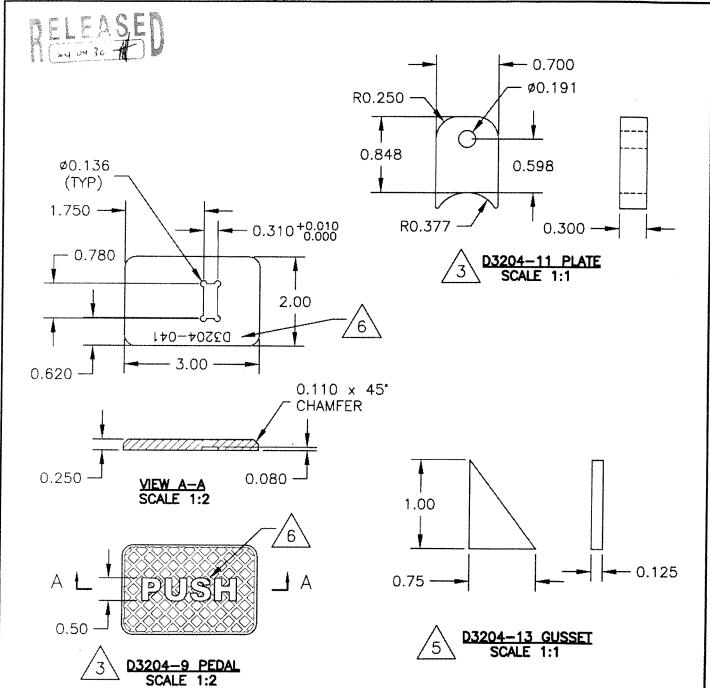
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4	#	D3204	SHEET 3 OF 3
DATE		TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS



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